

Work Order ID 147577

Wednesday, June 08, 2016 2:27:31 PM

147577

Page 1

Item ID: D350-689-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Provisions

Start Date: 6/10/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/22/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MCS Date: JUN 13 2016

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D350-689	C

JUL 06 2016

DAS
6
9-89

CL 16-07-07

100 Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D350-689 bluefile & type labels per PPP D350-689-013 CHG 005

X2
DAS
27
9-89
JUL 22 2016

(2)

101 Pick Kit

0.00

101

Packaging

Memo

0.00

Packaging

(2) PK

JUL 21 2016

110 QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.01

Quality Control

X3
DAS
27
9-89
JUL 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging			X2		DAS 27 9-89			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-013 Location: FC027					JUL 22 2016			
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.03					DAS 21 9-89		JUL 22 2016
Quality Control									

DAS
21
9-89 JUL 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
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								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
OTHER : ☐																									

Picklist Print

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Page 1

Work Order ID: 147577

147577

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

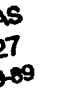
Start Date: 6/10/2016

Required Date: 6/22/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev D 06.02.07 Re-format ec
 IPP rev E 06.02.28 Fixed typo ec
 IPP rev.F 07.01.02 per dsi 9311 ec
 10.06.07 remove qty 1 D3033-1 DD verf:EC IPP Rev:G
 PER IIN REVB DD VERF:EC IPP REV:H 11.11.17
 ECN11-674 DD VERF:EC IPP REV:I 11.11.24 AS PER
 REV.B DD VERF:JLM IPP REV:J 12.11.20 AS PER DSI9588

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4575-3 *D4575-3* Doubler		Manufactured	No			110	Each	7.0000	1	2			P< 
				<u>Location</u>				<u>Loc Qty</u>					
				ST259				7					
				145611				7		2			
D3025-1 *D3025-1* Beam		Manufactured	No			110	Each	6.0000	1	2			P< 
				<u>Location</u>				<u>Loc Qty</u>					
				ST258				6					
				128214				6		2			
D4575-1 *D4575-1* Beam		Manufactured	No			110	Each	11.0000	1	2			P< JUL 21 2016 
				<u>Location</u>				<u>Loc Qty</u>					
				ST259				11					
				146063				11		2			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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147577

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 6/10/2016

Required Date: 6/22/2016

Start Qty: 2.00

Required Qty: 2.00

D3027-1
D3027-1
Clip

DAS
27
9-89

Manufactured No

110

Each

6.0000

1 2

**

x2 B1477 726 PC DAS 9-89

Location

Loc Qty

Loc Code

ST015

6

113247

1

B134425

5

D3027-3
D3027-3
Clip

DAS
27
9-89

Manufactured No

110

Each

10.0000

1 2

**

PC DAS 9-89

Location

Loc Qty

Loc Code

ST015

10

127761

2

128215

8

D3027-5
D3027-5
Clip

DAS
27
9-89

Manufactured No

110

Each

11.0000

1 2

**

PC DAS 9-89

Location

Loc Qty

Loc Code

ST015

11

127820

3

128216

8

D3027-7
D3027-7
Clip

DAS
27
9-89

Manufactured No

110

Each

21.0000

4 8

**

PC JUL 21 2016 DAS 9-89

Location

Loc Qty

Loc Code

ST015

21

147054

21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Page 3

Work Order ID: 147577

147577

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 6/10/2016

Required Date: 6/22/2016

Start Qty: 2.00

Required Qty: 2.00

D3032-1
D3032-1
Spacer

DAS
27
9-89

Manufactured No

110

Each

7.0000

1

2

PC

Location

Loc Qty

Loc Code

ST259

7

113083

7

2

D3033-1
D3033-1
Seat Track

Manufactured No

110

Each

1.0000

2

4

X4 B147526 PZ

Location

Loc Qty

Loc Code

ST259

1

137477

1

D3234-1
D3234-1
Doubler

DAS
27
9-89

Manufactured No

110

Each

11.0000

1

2

PC

Location

Loc Qty

Loc Code

ST258

11

127418

2

128218

9

D3234-5
D3234-5
Spacer

DAS
27
9-89

Manufactured No

110

Each

10.0000

2

4

PC JUL 21 2016

Location

Loc Qty

Loc Code

ST026

10

127482

2

128265

8

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
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Page 4

Work Order ID: 147577

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Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 6/10/2016

Required Date: 6/22/2016

Start Qty: 2.00

Required Qty: 2.00

MS21059L3

Purchased

No

110

Each

131.0000

12

24

MS21059L3

Nut Plate

MISSOIS PC

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

8

M129682

8

GA

18

M133990

18

ST301

79

M134257

9

M134762

70

ST303

26

M133016

26

MS24693-S273

Purchased

No

110

Each

511.0000

2

4

MS24693-S273

Screw

PC JUL 2 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

94

M129682

94

GA

18

117291

18

ST292

399

100151

399

DQA: _____ Date: _____



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Picklist Print

Wednesday, June 08, 2016 2:27:30 PM

Page 5

Work Order ID: 147577

147577

Parent Item: D350-689-013

D350-689-013

Parent Item Name: Floor Provisions

Start Date: 6/10/2016

Required Date: 6/22/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-10

Purchased

No

110

Each

598.0000

6

12

MS27039-1-10

SCREW

PC

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CA
m128635
GA
m129541
over006
m134676
ST280
m134567

41
41
14
14
300
300
243
243

12

NAS1149D0332J

Purchased

No

110

Each

1,258.000

6

12

NAS1149D0332.J

Washer

PC

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CA
m129682
FP001
m134502
ST260a
m134738
m134848
ST264
m134502

6
6
22
22
1200
600
600
30
30

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
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LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
1		1				D3018-1	SEAT CUSHION
1		1				D3019-1	BACK CUSHION
	1					D3025-1	BEAM
	1					D3027-1	CLIP
	1					D3027-3	CLIP
	1					D3027-5	CLIP
	4		4			D3027-7	CLIP
				4		D3028-1	STUD
				2		D3029-1	SPRING
				2		D3030-1	LOCK
	1					D3032-1	SPACER
	2					D3033-1	SEAT TRACK
	1					D3234-1	DOUBLER
	2					D3234-5	SPACER
					2	D3808-041	SEAT RAIL ASSEMBLY
					4	D3809-1	SLIDING BLOCK
			1			D3811-041	SEAT TRACK ASSEMBLY
	1		1			D4575-1	BEAM
	1		1			D4575-3	DOUBLER
				1	1	D5162-041	SEAT STRUCTURE ASSEMBLY
			9			MS21042L3	NUT (OR MS21042-3)
	12					MS21059L3	NUTPLATE
	2					MS24693-S273	SCREW
			9			MS24694-S50	SCREW
	6					MS27039-1-10	SCREW
	6					NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)

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Revision: C

Date: 14.12.01